

ABSTRACT

The invention includes means for, when welding a crater in a welding termination portion, moving a torch in a direction allowing the whole of the torch to part apart from a
5 molten pool and, therefore, the invention can prevent all welding wires from coming into contact with the molten pool. Also, the invention can check not only the crater-welded welding wire but also all of the remaining welding wires for deposition and, if there is detected a deposited wire, can energize the deposition detected wire again to thereby be able to remove the deposition of the wire.

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